

Work Order ID 51238

August 12, 2009 8:11:02 AM



Page 1

Item ID: D3874-2

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector

Start Date: 08/12/2009 Start Qty: ~~1.00~~ ^{10 MF}



Cust Item ID:

Required Date: 08/18/2009 Req'd Qty: ~~1.00~~

Customer:

Reference:

Approvals: Process Plan: MF Date: 09-08-12 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

09/30/09
BB X10

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9453
Dwg Rev: AA
Folio Rev: A

09/30/09
BB X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51238

August 12, 2009 8:11:02 AM



Page 2

Item ID: D3874-2

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector

Start Date: 08/12/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/18/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

09/30/09
PB

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

09/10/05
DH X10

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

09/10/05
BB X10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



Work Order ID 51238




August 12, 2009 8:11:02 AM



Page 3

Item ID: D3874-2 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Floor Protector
Start Date: 08/12/2009 Start Qty: 4.00  Cust Item ID:
Required Date: 08/18/2009 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Complete FAI document	0.00 0.00							BB 09/10/09 X 10
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							40 4
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							9/10/09 100 SQ

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 51238

August 12, 2009 8:11:02 AM



Page 4

Item ID: D3874-2

Accept



Setup Start



Revision ID: A

Item Name: Floor Protector

Stop



Start Date: 08/12/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/18/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07

09-10-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 12, 2009 8:11:02 AM

Page 1

Work Order ID: 51238



Parent Item: D3874-2RevA



Parent Item Name: Floor Protector

Start Date: 08/12/2009

Required Date: 08/18/2009

Comments:

Start Qty: 4.00 /

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	481.7400	17.5200 4,38			



Lexan Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

481.74

111588

481.74

MISSISS

BB 09/30/09
(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51238
Description: Floor Protector		Part Number: D3874-2
Inspection Dwg: D3874	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/30/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	.097	✓			
0.065	Min	.082	✓			
0.5	Min	.525	✓			
21.9	REF	22	✓			

Measured by: BB

Date: 09/30/09

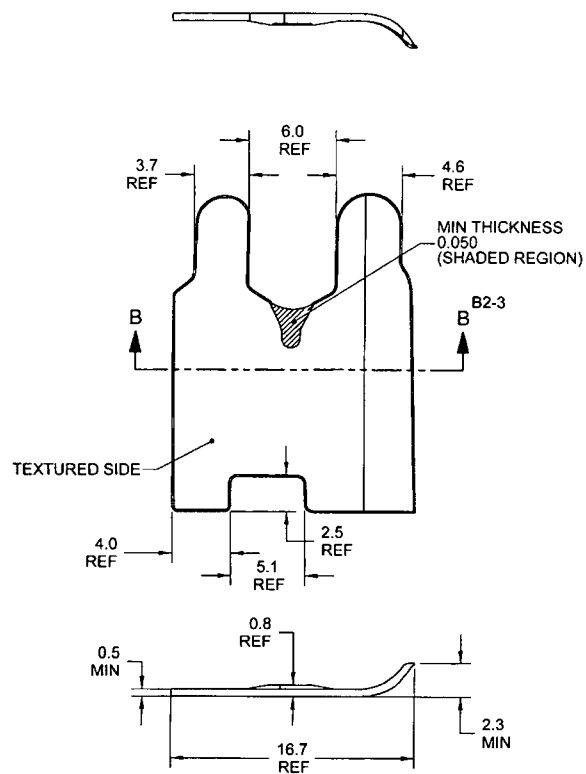
Audited by: WHL

Date: 09/30/09

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>AA</u>



D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

#51238
mf
09-08-12



SECTION B-B
SCALE 2X

RELEASED
09/05/12

DESIGN	PT	DART AEROSPACE LTD	
DRAWN	PT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PT	DRAWING NO. D3874	REV. A
MFG. APPR.	PT	SHEET 3 OF 3	
APPROVED	PT	TITLE	SCALE
DE APPR.	PT	FLOOR PROTECTOR	NTS
DATE	09.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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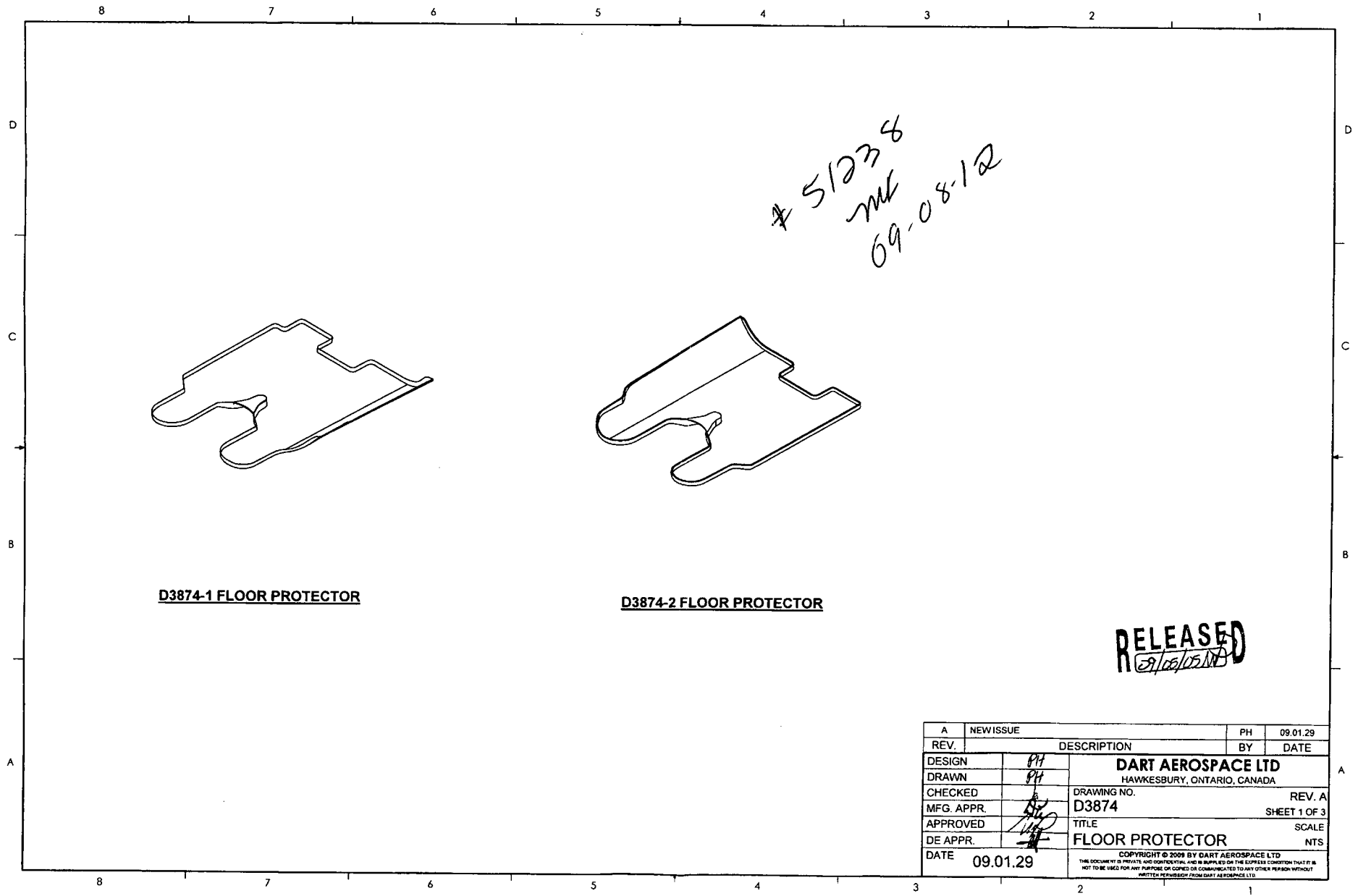
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NOTE: Date & initial all entries



D3874-1 FLOOR PROTECTOR

D3874-2 FLOOR PROTECTOR

RELEASED
27/05/05

A		NEW ISSUE		PH	09.01.29
REV.	DESCRIPTION			BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 3	
DRAWN	PH				
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D3874		SCALE	
APPROVED		TITLE		NTS	
DE APPR.		FLOOR PROTECTOR			
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